

Date: Monday, 12/11/2006 12:54:06 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : END CAP  
 Job Number : 29849  
 Estimate Number : 11675  
 P.O. Number : N/A Part Number : D28502  
 This Issue : 12/11/2006 S.O. No. : N/A Drawing Number : D28502 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A  
 Previous Run : N/A Material : N/A  
 Written By : Due Date : 1/20/2007 Qty: 20 Um: Each  
 Checked & Approved By : J. L. 06/12/11  
 Comment : Est. B 98.12.07 Changed folio DM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2500X01500 6061-T6 Bar 2.5" x 1.5"



Comment: Qty.: 0.3368 f(s)/Unit Total: 6.7368 f(s) M100947 x 2.3576 f(s)  
 6061-T6 Bar 2.5" x 1.5"  
 6061-T6 2.5" X 1.5" Batch M9877 x 4.3784 f(s) J.L. 07/01/03

2.0 SHEAR SHEAR



Comment: SHEAR  
 Shear blanks: 3.8"

J.L. 07/01/03

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine per Folio D2850-2  
 Deburr and Tumble

J.L./J.F. 07/01/04

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L./J.F. 07/01/04

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: 57389

Second Check: J.L. 7/01/05 (20)  
 SD 07.01.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/08

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: END CAP

Job Number: 29849

Part Number: D28502

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



20

Comment: FINAL INSPECTION/W/O RELEASE

2076/108

Job Completion



u 0720108

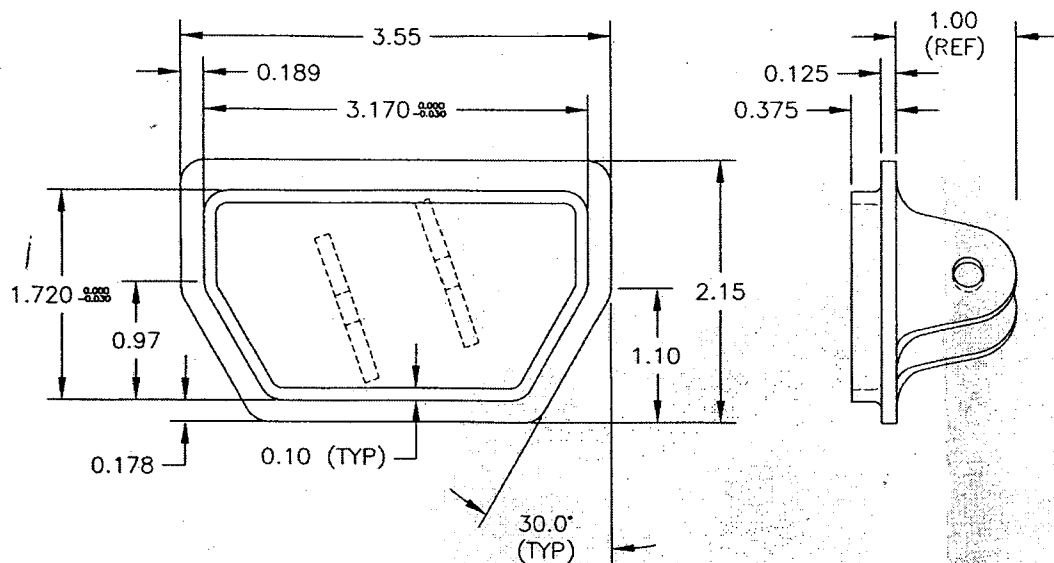
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



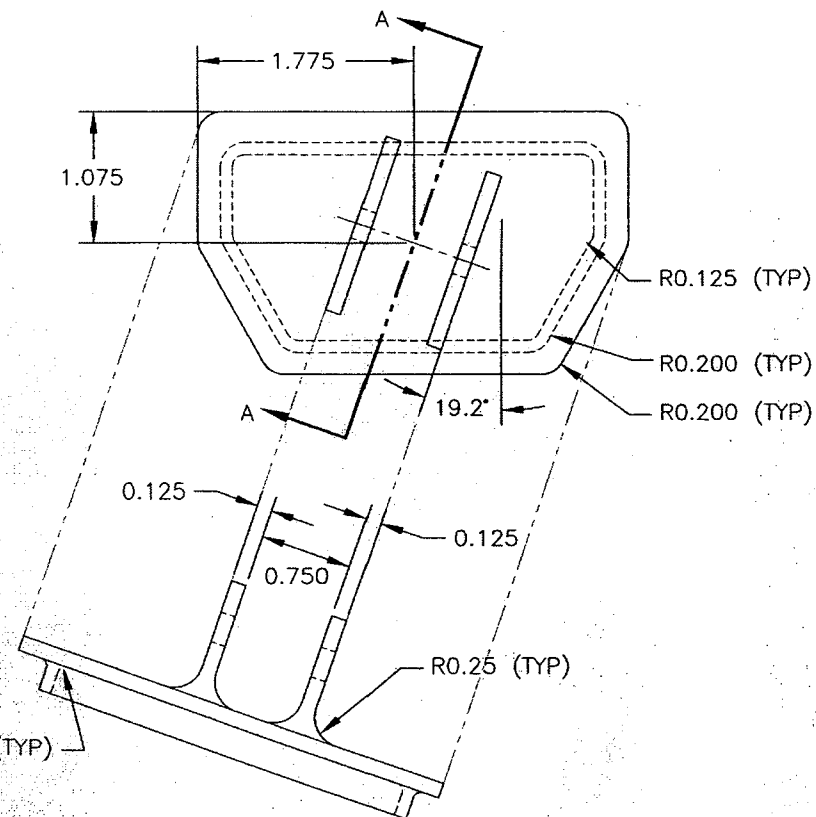
D2850-1 (SHOWN)  
D2850-2 (OPPOSITE)

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)

FINISH: NONE

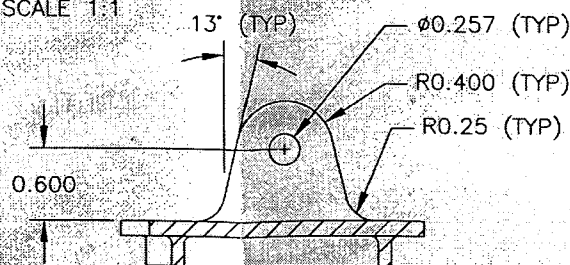
BREAK ALL SHARP EDGES 0.010 TO 0.020

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED



ISOMETRIC DETAIL  
NOT TO SCALE

SECTION A-A  
SCALE 1:1



RELEASED  
98.11.25 KE

A	98.11.10	NEW ISSUE, REPLACES D2357 REV. A AND D2358 REV. B	
DESIGN CP	DRAWN BY CP	<b>DART</b> DART AEROSPACE LTD. WARRICKSURY, OXFORD, CANADA	REV. A
CHECKED KE	APPROVED #	DRAWING NO. D2850	SHEET 1 OF 1
DATE 98.11.10	TITLE HIGH FLOAT STEP END BRACKET		SCALE 1:1

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WORK ORDER  
NO 29849  
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WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY

